

**D3905-041 FLOAT SKIDTUBE ASSY WITH WEARPAD (SHOWN)**  
**D3905-043 FLOAT SKIDTUBE ASSY WITH WEARPLATE (SIMILAR)**  
**D3905-045 FLOAT SKIDTUBE ASSY WITH TRAINING WEARPLATE (SIMILAR)**

**UNDER REVIEW**

URF # 18-789 NO 18-08-24

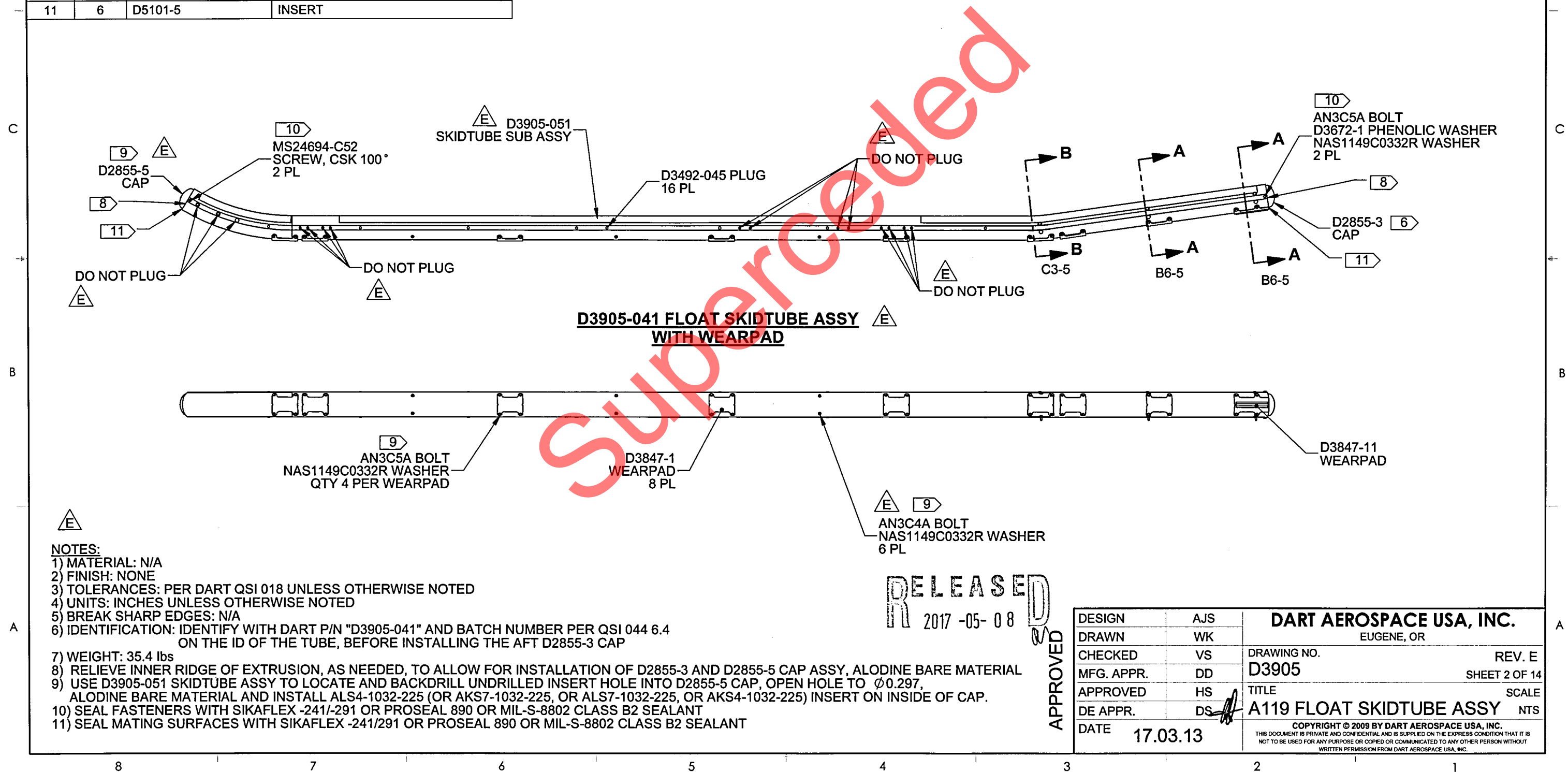
E	COMPLETE REDRAW SEE PREVIOUS REV. AFT FLOAT HOLE NOW Ø0.465 WAS Ø0.437 FINISH REMOVED FROM SADDLE AREA SEE DETAIL F. REF PAR15-421 CHANGE QTY OF D2855-3, ADDED D2855-5 CAP ASSEMBLIES. ADDED INSTRUCTIONS TO LOCATE INSERT HOLE FOR D2855-5 CAP. REF PAR17-583 ADDED DRILL JIG REF NUMBER. NCR15-5366 INCREASE RIDGE RELIEF FROM 0.060 TO 0.130. REF PAR17-574	AJS / WK	17.03.13
D	REVISED DIMENSIONS AND PROVIDED TOLERANCE TO SKIDTUBE OVERALL LENGTH PAGE 5-6 REVISED NOTE 2 AND NOTE 7 PAGE 1 (ZN B8-, ZN A8-1) REVISED -041/-043/-045 DRAWING VIEWS. REVISED SECTION VIEW F-F (ZN B4-7). REVISED BOM REF. PAR13-299 AND PAR13-272	AK	14.08.08
C	(SHT 1 P/L. ZN C2-2, C2-3, C2-4) ITEM 13, QTY 2 WAS 4, ITEM 42 AND 45, QTY 44 WAS 46, ADD ITEM 49, MS24694-C52 WAS AN3C5A, D3672-1 AND NAS1149C0332R, (ZN C7-7) Ø0.201 CSK Ø0.385 X 100" WAS Ø0.204 THRU, (ZN A4-5, A4-6) ADD RELIEF INSTRUCTION, ADD ITEM 10, CROSS BOLT SPACER (ZN D4-1, C6-7, D8-7)	DB	13.02.21
B	REVISED PART LIST, ALS4-1032-130 WAS AELS-1032-130 (ZN A6-5, A5-6, C5-7, C3-7, A5-7); ADD DT8932 (ZN A8-1); D2855-3 WAS D2575 (ZN C8-2, C1-2, C8-3, C1-3, C8-4, C1-4); AN3C5A WAS AN3C4A (ZN C7-2, C1-2, C7-3, C1-3, C7-4, C1-4); D3849-047 WAS D3849-041 (ZN B3-4); ADD D3411-3 (ZN B3-4); ADD AN3C50A (ZN B3-4); Ø0.313 WAS Ø0.328 (B2-5, B2-6, C2-7, A8-7 & D7-8), REVISED NOTE iv (ZN A8-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE USA, INC.</b> EUGENE, OR	
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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 1 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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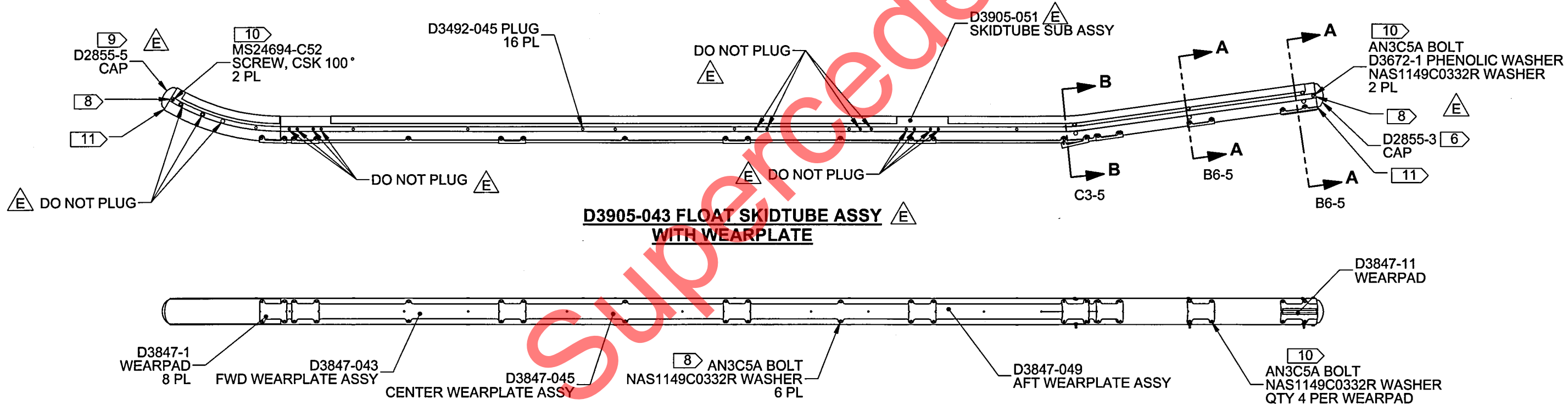
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3905-041	SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	8	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3905-051	SKIDTUBE SUB ASSEMBLY
8	2	D5101-041	CROSSBOLT SPACER ASSY
9	1	D5101-047	CROSSBOLT SPACER ASSY
10	6	D5101-3	INSERT
11	6	D5101-5	INSERT

ITEM	QTY -041	P/N	DESCRIPTION
12	1	ALS4-1032-225	INSERT
13	6	AN3C4A	BOLT
14	38	AN3C5A	BOLT
15	3	AN4C46A	BOLT
16	3	MS21043-4	NUT, SELF-LOCKING
17	2	MS24694-C52	SCREW, CSK 100°
18	44	NAS1149C0332R	WASHER
19	6	NAS1149C0416R	WASHER



ITEM	QTY -043	P/N	DESCRIPTION
	X	D3905-043	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3492-045	PLUG
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-043	FWD WEARPLATE ASSY
6	1	D3847-045	CENTER WEARPLATE ASSY
7	1	D3847-049	AFT WEARPLATE ASSY
8	8	D3847-1	WEARPAD
9	1	D3847-11	WEARPAD
10	1	D3905-051	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSSBOLT SPACER ASSY
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -043	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	44	AN3C5A	BOLT
17	3	AN4C46A	BOLT
18	3	MS21043-4	NUT, SELF-LOCKING
19	2	MS24694-C52	SCREW, CSK 100°
20	44	NAS1149C0332R	WASHER
21	6	NAS1149C0416R	WASHER



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-043" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
- 7) WEIGHT: 42.8 lbs
- 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
- 9) USE D3905-051 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO  $\varnothing 0.297$ , ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
- 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
- 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

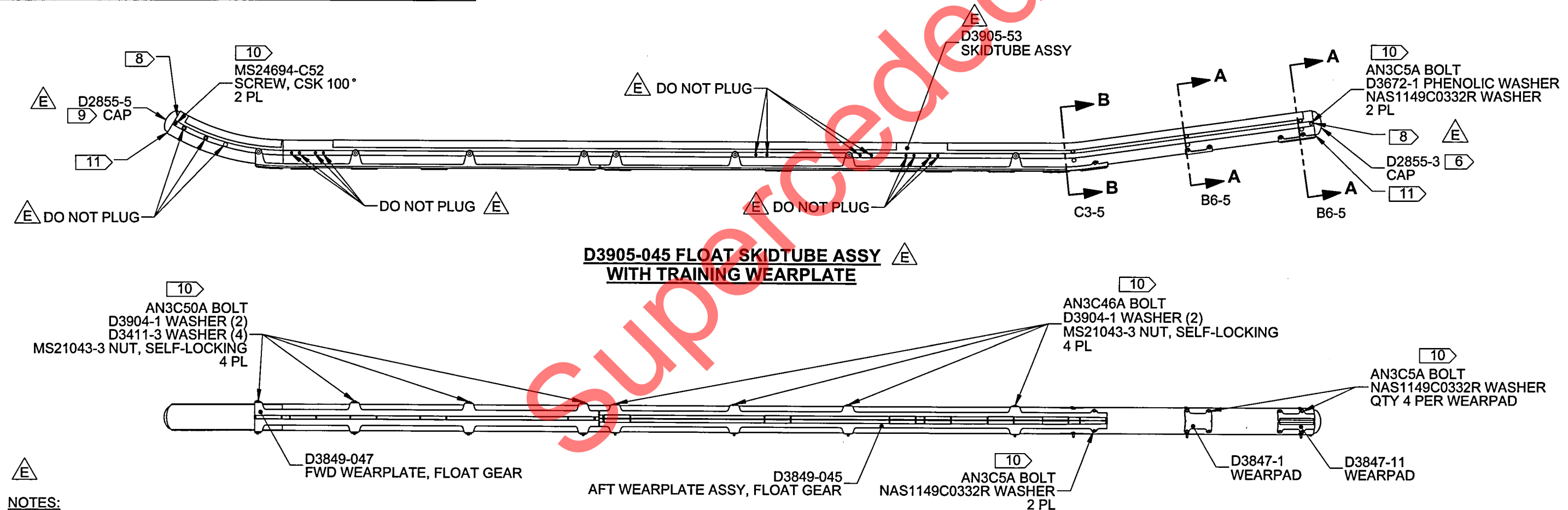
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ITEM	QTY -045	P/N	DESCRIPTION
	X	D3905-045	FLOAT SKIDTUBE ASSY
1	1	D2855-3	CAP
2	1	D2855-5	CAP
3	16	D3411-3	WASHER
4	2	D3672-1	PHENOLIC WASHER
5	1	D3847-1	WEARPAD
6	1	D3847-11	WEARPAD
7	1	D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
8	1	D3849-047	FWD WEARPLATE, FLOAT GEAR
9	16	D3904-1	WASHER
10	1	D3905-053	SKIDTUBE SUB ASSEMBLY
11	2	D5101-041	CROSSBOLT SPACER ASSY
12	1	D5101-047	CROSS BOLT SPACER
13	6	D5101-3	INSERT
14	6	D5101-5	INSERT

ITEM	QTY -045	P/N	DESCRIPTION
15	1	ALS4-1032-225	INSERT
16	12	AN3C5A	BOLT
17	4	AN3C46A	BOLT
18	4	AN3C50A	BOLT
19	3	AN4C46A	BOLT
20	8	MS21043-3	NUT, SELF-LOCKING
21	3	MS21043-4	NUT, SELF-LOCKING
22	2	MS24694-C52	SCREW, CSK 100°
15	12	NAS1149C0332R	WASHER
24	6	NAS1149D0416J	WASHER



- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3905-045" AND BATCH NUMBER PER QSI 044 6.4 ON THE ID OF THE TUBE, BEFORE INSTALLING THE AFT D2855-3 CAP
  - 7) WEIGHT: 48.0 lbs
  - 8) RELIEVE INNER RIDGE OF EXTRUSION, AS NEEDED, TO ALLOW FOR INSTALLATION OF D2855-3 AND D2855-5 CAP ASSY, ALODINE BARE MATERIAL
  - 9) USE D3905-053 SKIDTUBE ASSY TO LOCATE AND BACKDRILL UNDRILLED INSERT HOLE INTO D2855-5 CAP, OPEN HOLE TO  $\varnothing 0.297$ , ALODINE BARE MATERIAL AND INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR ALS7-1032-225, OR AKS4-1032-225) INSERT ON INSIDE OF CAP.
  - 10) SEAL FASTENERS WITH SIKAFLEX -241/-291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT
  - 11) SEAL MATING SURFACES WITH SIKAFLEX -241/291 OR PROSEAL 890 OR MIL-S-8802 CLASS B2 SEALANT

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8 7 6 5 4 3 2 1

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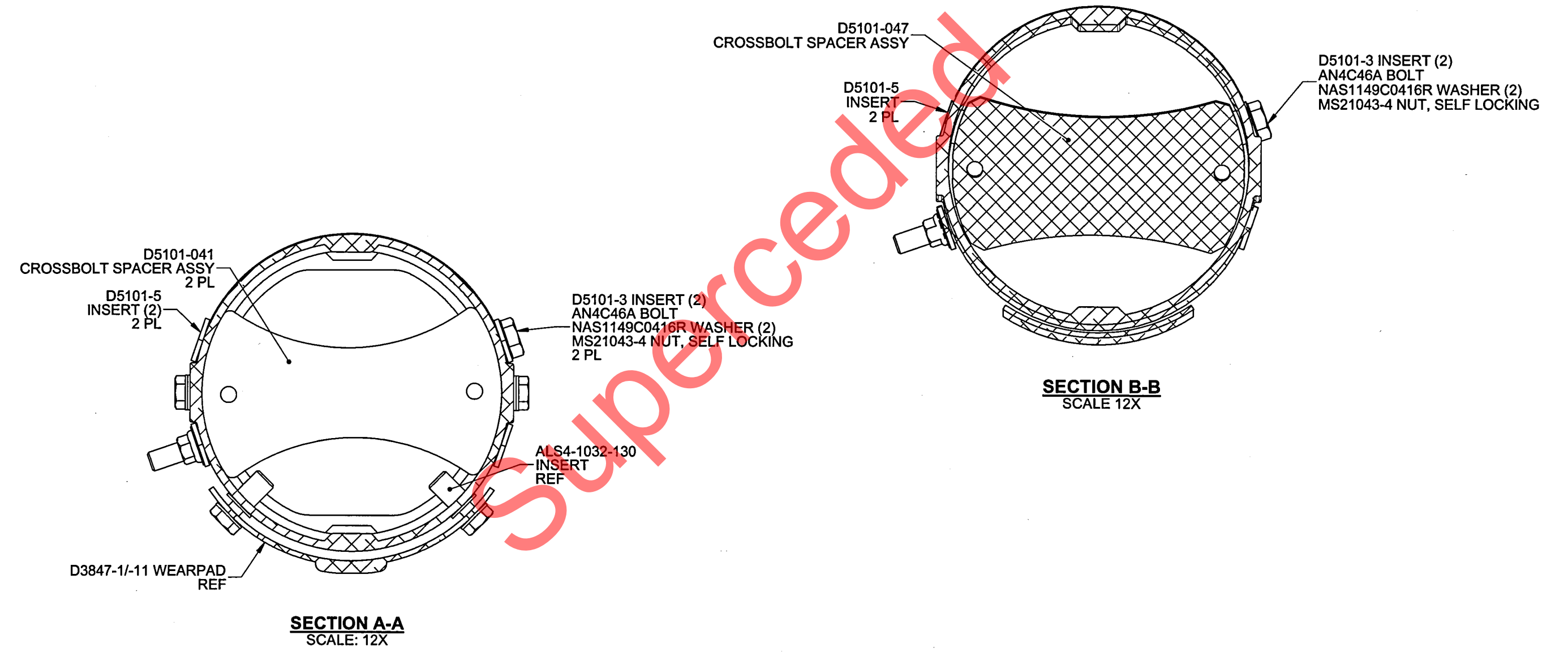
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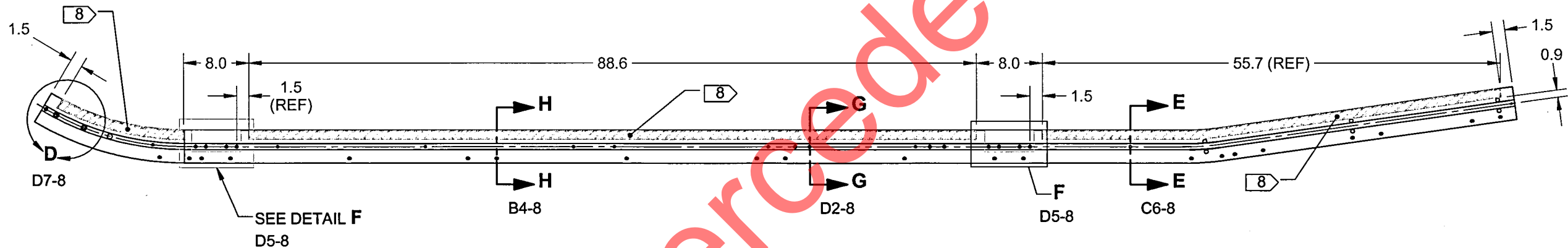


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ITEM	QTY -051	P/N	DESCRIPTION
	X	D3905-051	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-061	SKIDTUBE SUB ASSEMBLY
5	42	ALS4-1032-130	INSERT



**D3905-051 SKIDTUBE SUB ASSEMBLY**

**NOTES:**

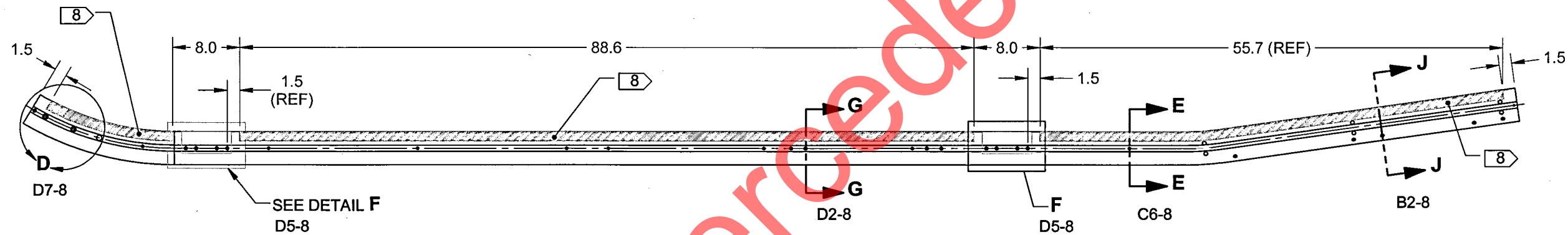
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- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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ITEM	QTY -053	P/N	DESCRIPTION
	X	D3905-053	SKIDTUBE SUB ASSY
1	2	D2579	CROSS BOLT SPACER
2	8	D3681-1	SPACER
3	12	D3903-1	SPACER
4	1	D3905-063	SKIDTUBE SUB ASSEMBLY
5	10	ALS4-1032-130	INSERT



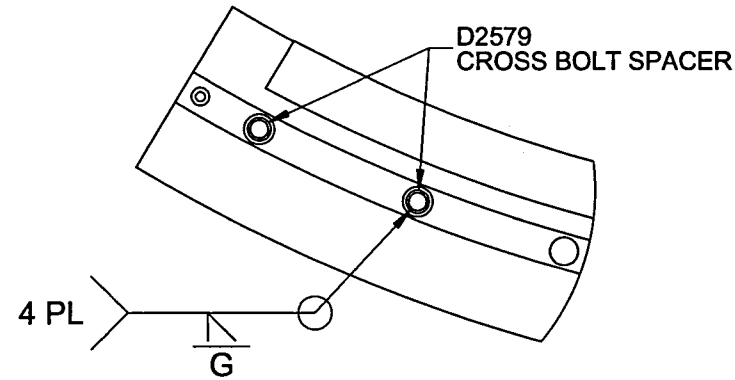
**D3905-053 SKIDTUBE SUB ASSEMBLY**

**NOTES:**

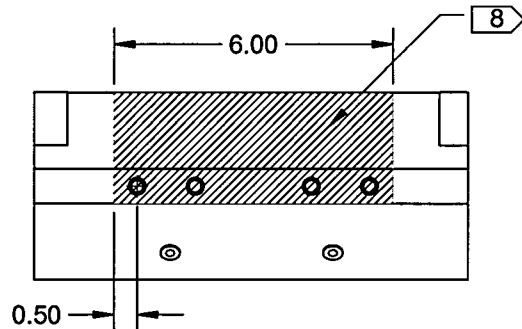
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- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY AT NEXT ASSEMBLY
- 7) WEIGHT: N/A
- 8) AFTER APPLICATION OF FINISH, PAINT TOP SURFACE OF SKIDTUBE WITH MIL-W-5044 ANTI-SKID PAINT (WING WALK) AS INDICATED TO 0.50" ABOVE LOCATION RIDGE, PER QSI 005 SECTION 4.4

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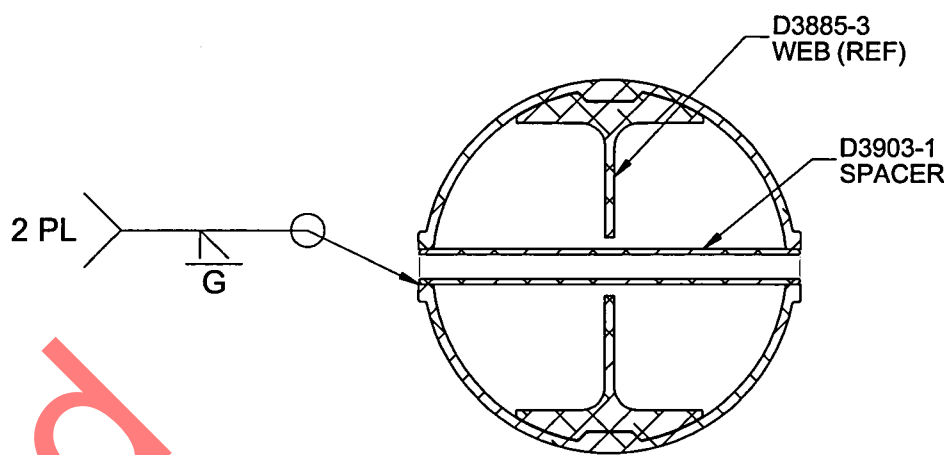
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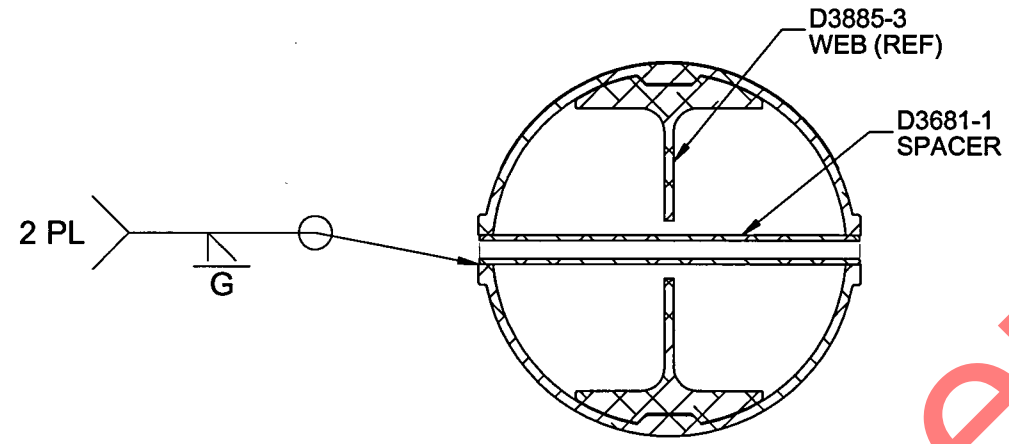
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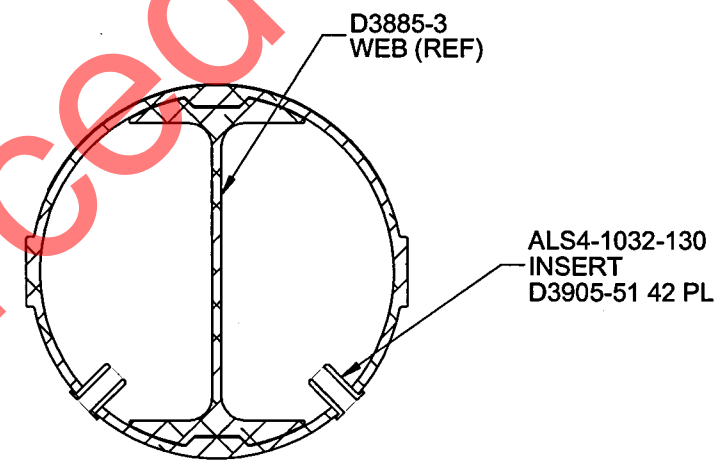
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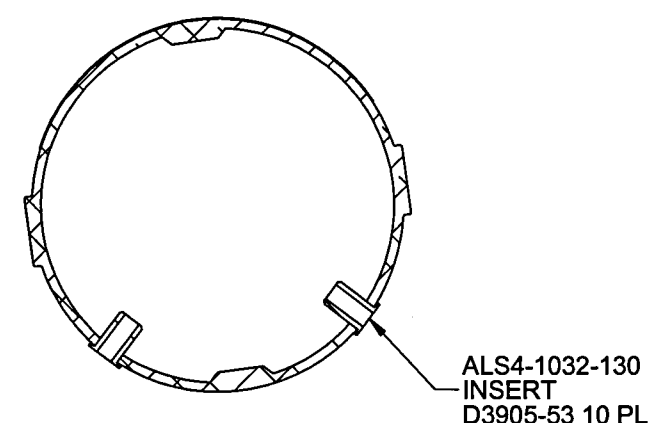
**SECTION G-G**  
SCALE: 7X  
12 PL



**SECTION E-E**  
SCALE: 7X  
8 PL



**SECTION H-H**  
SCALE: 7X  
D3905-51 21 PL



**SECTION J-J**  
SCALE: 7X  
D3905-53 5 PL

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: PRIME (REF 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.2.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) MASK THIS AREA AND DO NOT APPLY PRIMER OR PAINT
- 9) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION G-G  $\varnothing 0.375$  HOLES ONLY:
  - i) CHAMFER HOLES  $\varnothing 0.475 \times 45^\circ$
  - ii) INSERT D3903-1 SPACER
  - iii) WELD INTO PLACE AND GRIND FLUSH
  - iv) C'BORE TO  $\varnothing 0.313 \times 0.75$  DEEP
  - v) DEBURR HOLES
- 10) AFTER DRILLING AND BENDING ASSEMBLY, PERFORM THE FOLLOWING FOR THE SECTION E-E  $\varnothing 0.313$  HOLES ONLY:
  - i) CHAMFER HOLES  $\varnothing 0.354 \times 45^\circ$  OR  $0.050$  DEEP  $\times 45^\circ$  (BOTH SIDES)
  - ii) INSERT D3681-1 SPACER
  - iii) WELD INTO PLACE AND GRIND FLUSH
  - iv) DEBURR HOLES
- 11) WELD PER DART QSI 004

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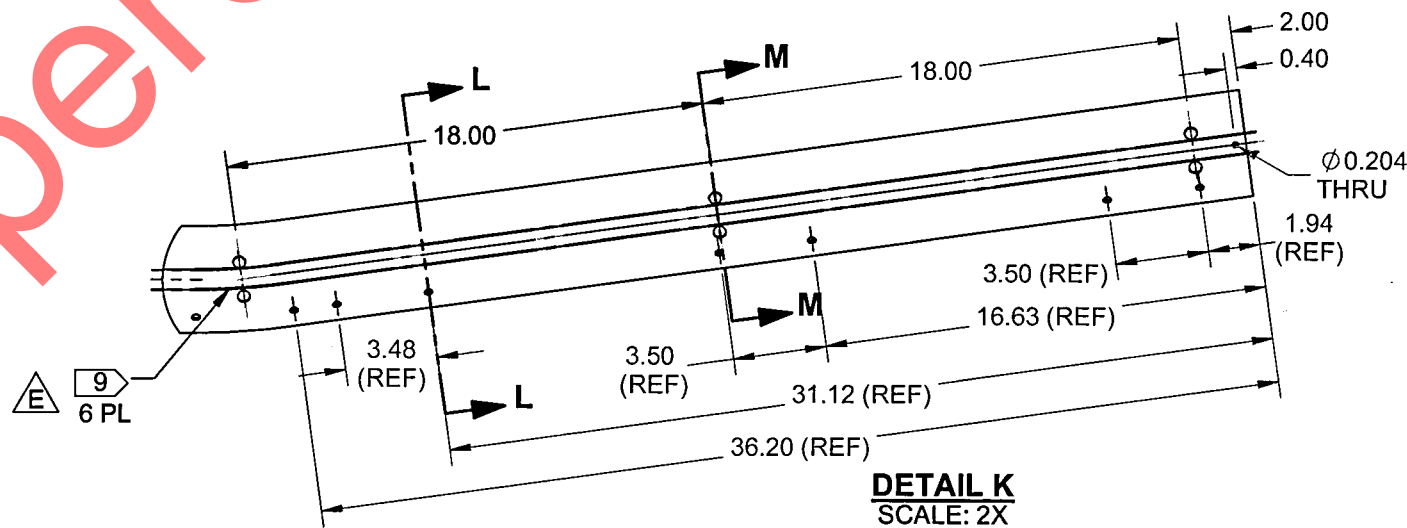
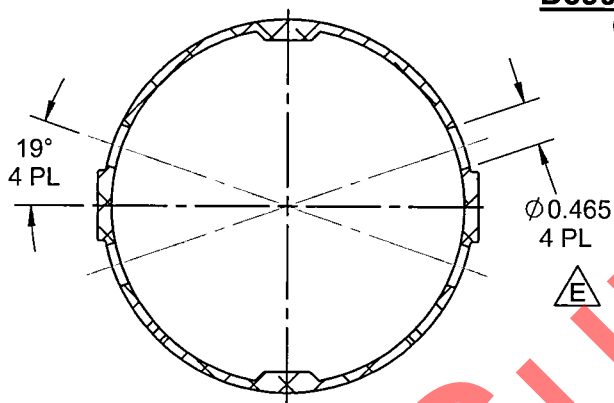
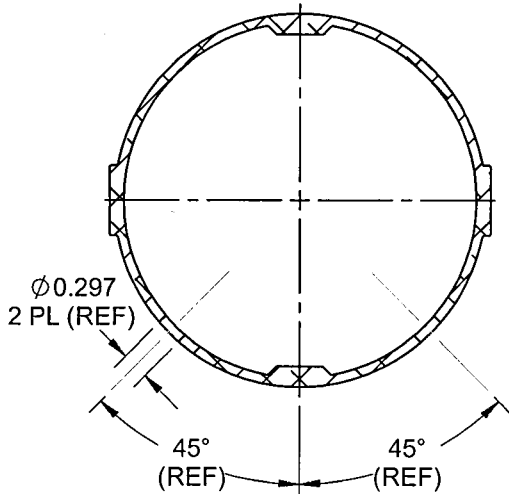
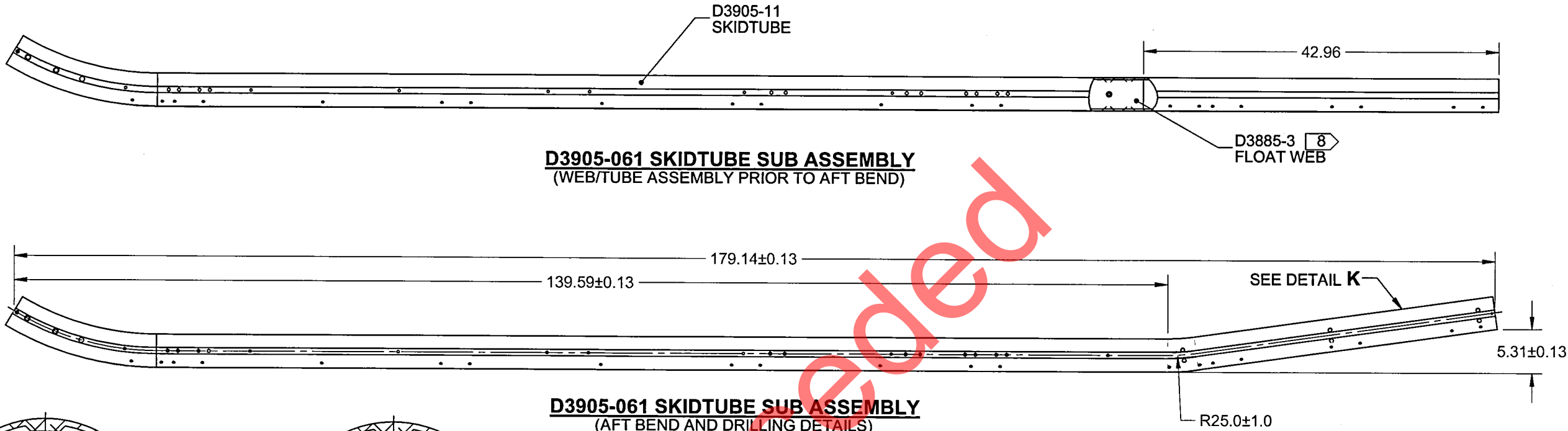
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DE APPR.	DS
DATE	17.03.13

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DRAWING NO. <b>D3905</b>	REV. E SHEET 8 OF 14
TITLE <b>A119 FLOAT SKIDTUBE ASSY</b>	SCALE NTS
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ITEM	QTY -061	P/N	DESCRIPTION
		D3905-061	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-11	SKIDTUBE



**NOTES:**

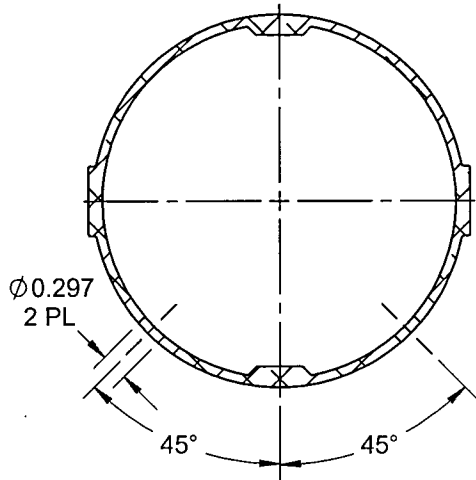
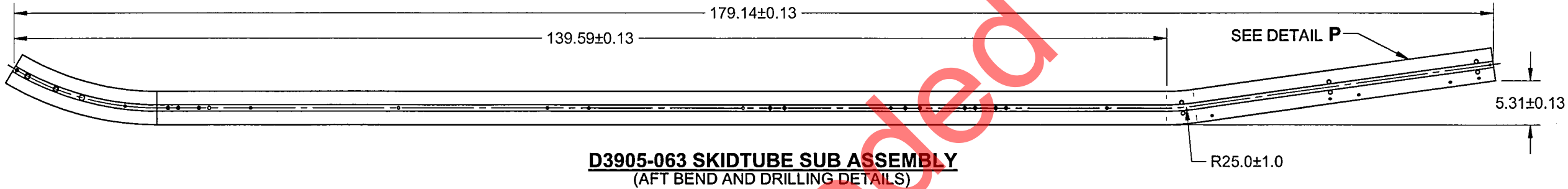
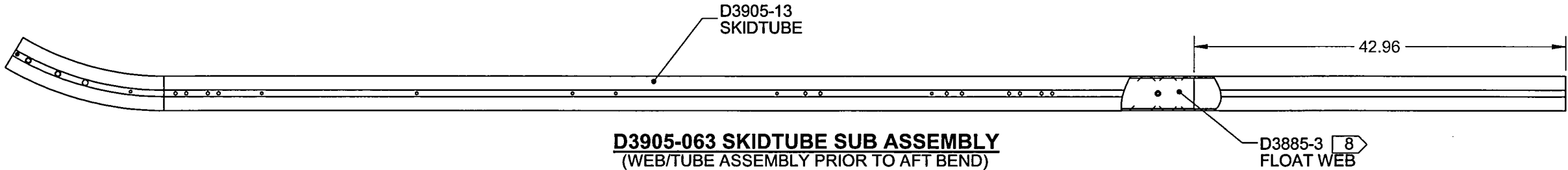
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
- 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSERT CLEARANCE, MAX 0.130 INTO RIDGE

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CHECKED	VS	DRAWING NO.	REV. E
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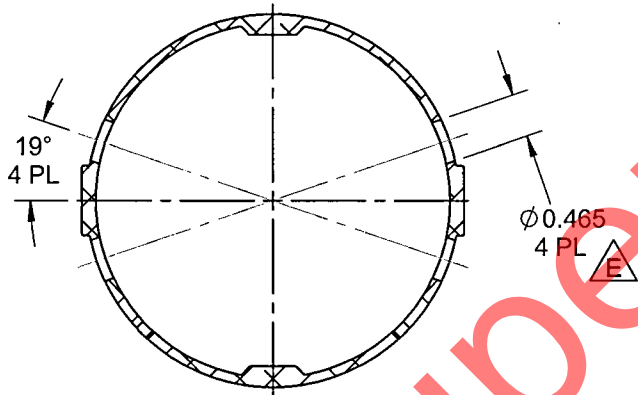
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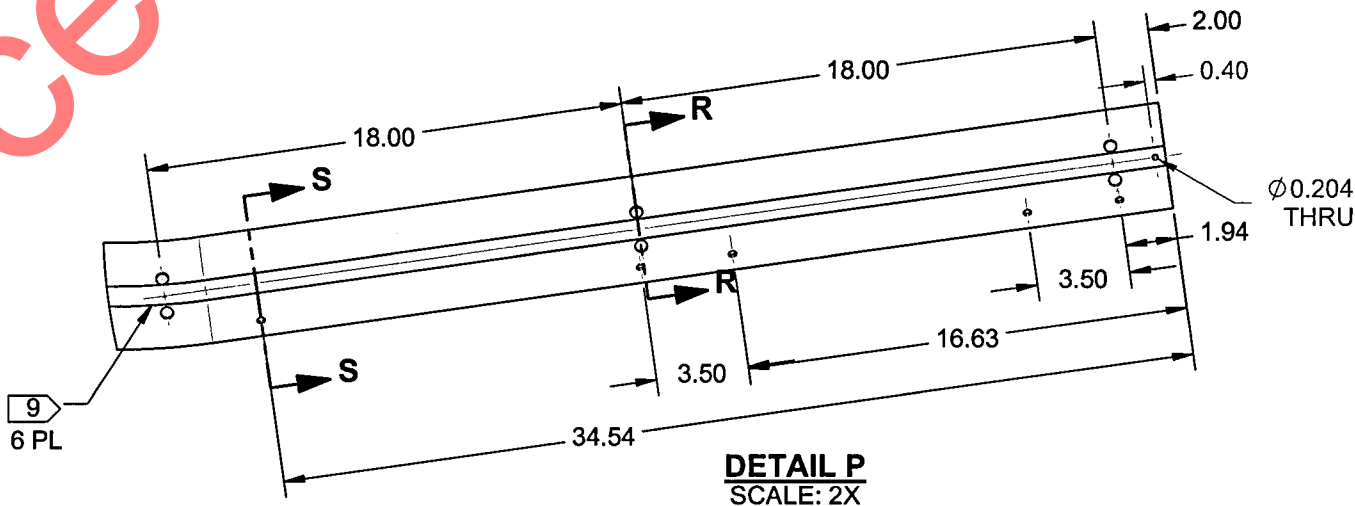
ITEM	QTY -063	P/N	DESCRIPTION
	X	D3905-063	SKIDTUBE SUB ASSEMBLY
1	1	D3885-3	FLOAT WEB
2	1	D3905-13	SKIDTUBE



SECTION S-S  
5 PL  
SCALE: 7X



SECTION R-R  
3 PL  
SCALE: 7X

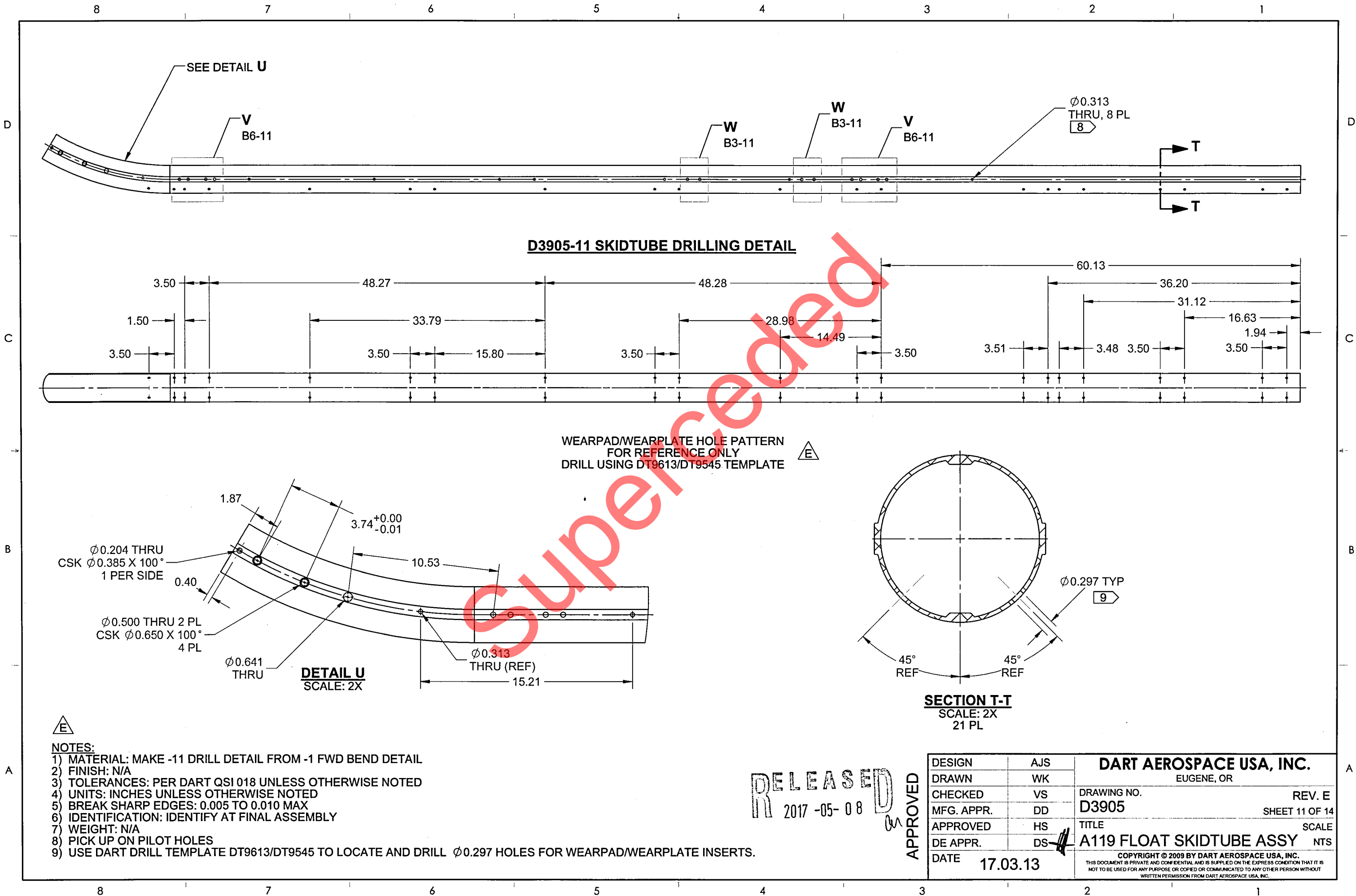


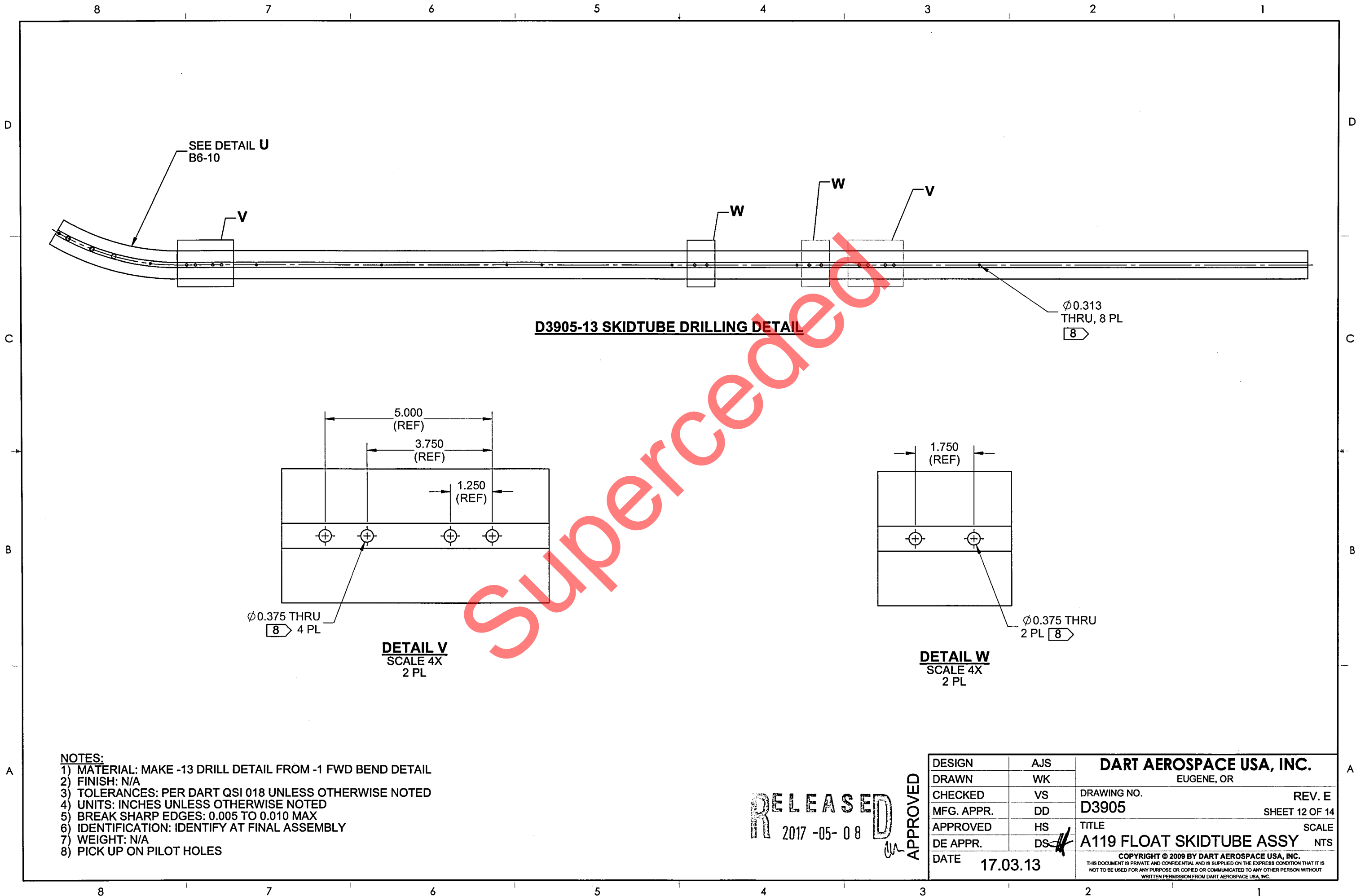
- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
  - 7) WEIGHT: N/A
  - 8) INSERT D3885-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING. ENSURE HOLES LINE-UP
  - 9) RELIEVE RIDGE FLUSH WITH SKIDTUBE FOR INSTERT CLEARANCE, MAX 0.130 INTO RIDGE

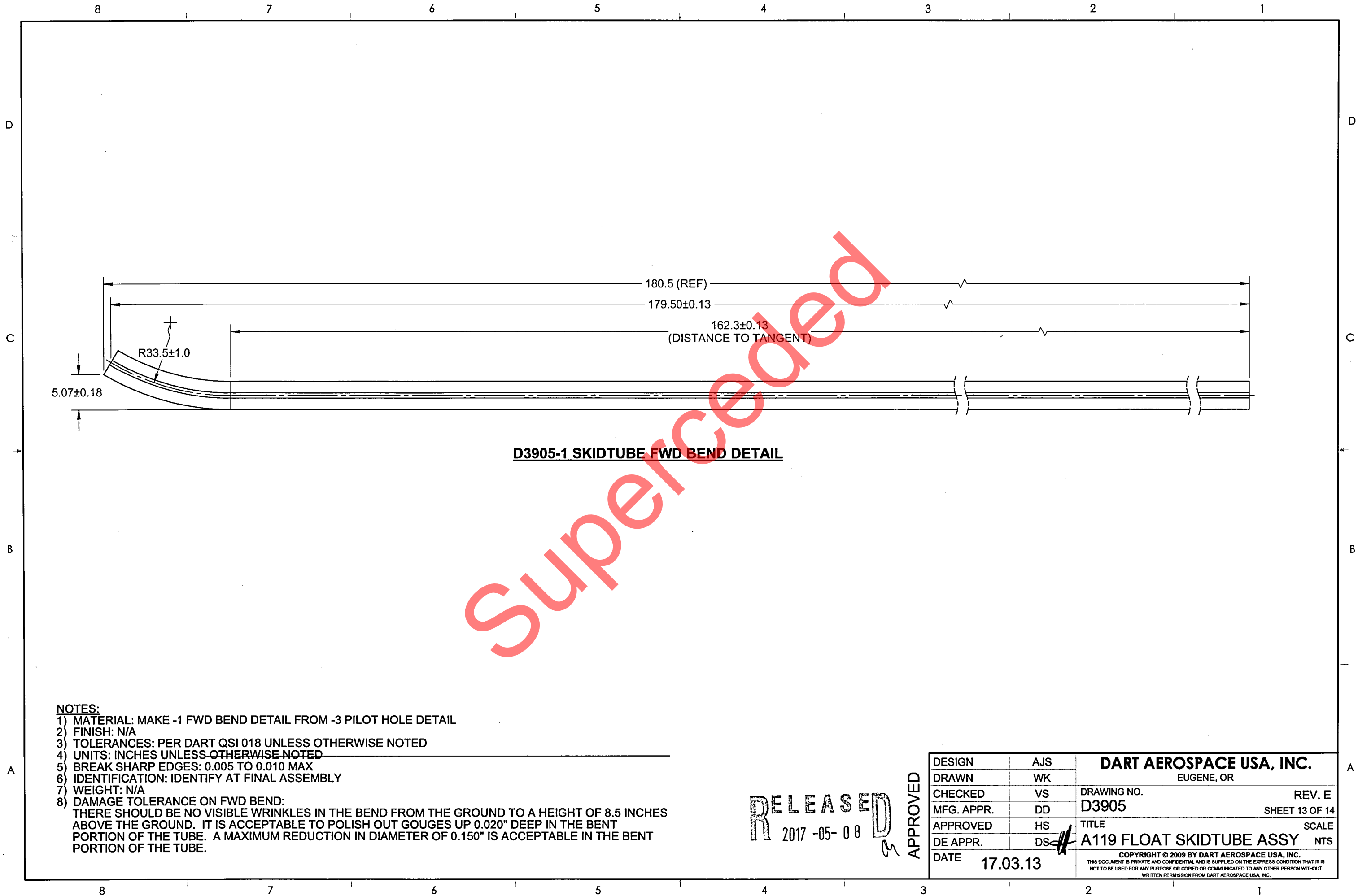
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DESIGN	AJS	DART AEROSPACE USA, INC.	
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CHECKED	VS	DRAWING NO.	REV. E
MFG. APPR.	DD	D3905	SHEET 10 OF 14
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
DATE	17.03.13	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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**D3905-1 SKIDTUBE FWD BEND DETAIL**

**NOTES:**

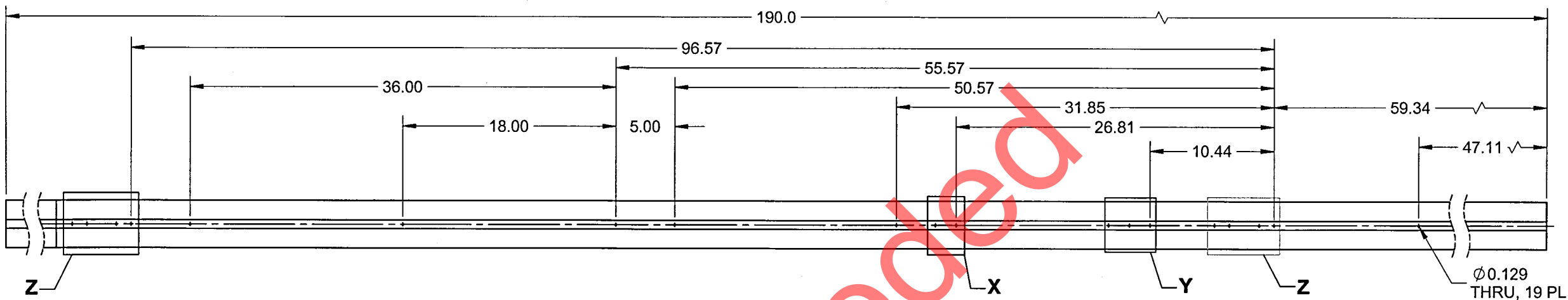
- 1) MATERIAL: MAKE -1 FWD BEND DETAIL FROM -3 PILOT HOLE DETAIL
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A
- 8) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 8.5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.

RELEASED  
2017-05-08

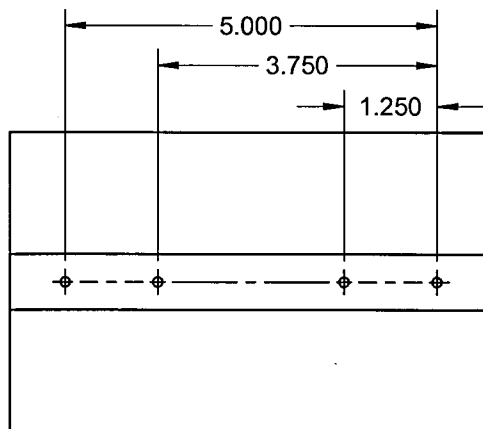
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MFG. APPR.	DD	D3905	SHEET 13 OF 14
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DE APPR.	DS	A119 FLOAT SKIDTUBE ASSY	NTS
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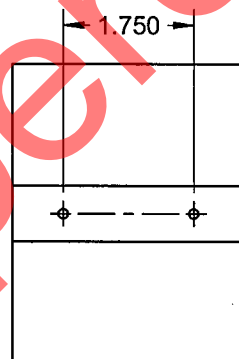




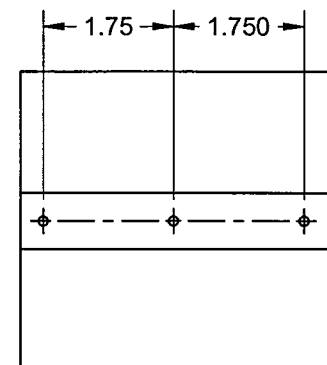
**D3905-3 SKIDTUBE PILOT HOLE DETAIL**



**DETAIL Z**  
SCALE: 4X



**DETAIL X**  
SCALE: 4X



**DETAIL Y**  
SCALE: 4X

**NOTES:**

- 1) MATERIAL: MAKE FROM D2500-1-190 EXTRUSION
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT FINAL ASSEMBLY
- 7) WEIGHT: N/A

**RELEASED**  
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APPROVED	HS	TITLE	SCALE
DE APPR.	DS	<b>A119 FLOAT SKIDTUBE ASSY</b>	NTS
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